

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2016-128 Date Opened: 23-Sept-16 Title: FabricationAircraft OEM: Bell Aircraft Model: 206B Product Type: Beams Product Model: N/A Quantity: 1 pair**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

JC
N/A
JC
JC
JC
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JC
JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
49730	1	Forward Beam	JC
49731	0	Aft Beam	JC

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

1 pair
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Traveller

Initial or N/A

Work performed by:

Print: D. BartfaiSign: SCA: AD07Date: 30-Sep-16

ICC / Dual Inspection performed by:

Print: J. ClarkeSign: SCA: AD02Date: 30-Sep-16

Work Order closed by:

Print: J. ClarkeSign: SCA: AD02Date: 11-Oct-16

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

WO#

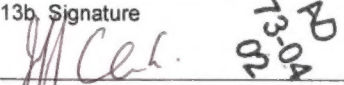
Approved Manufacturing Facility 73-04

Rev. Original 27 May 2013



WO#

Approved Manufacturing Facility 73-04 Form 20.F.06 Rev. Original 27 May 2013

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2016-0192
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2016-128
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Forward Beam	49730-01	1	N/A	New
2.	Aft Beam	49731-01	1		
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 07 Oct 2016		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

BLACKSWAN HELICOPTERS

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	DOWN TUBE LOCATION CHANGED	BUC	OCT 09/01



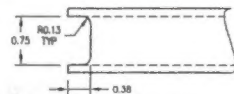
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C.
WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT FOR STAINLESS STEEL.
3. ALL STEEL PARTS TO BE THOROUGHLY DEGREASED AND POWDER COATED PRIOR TO INSTALLATION.



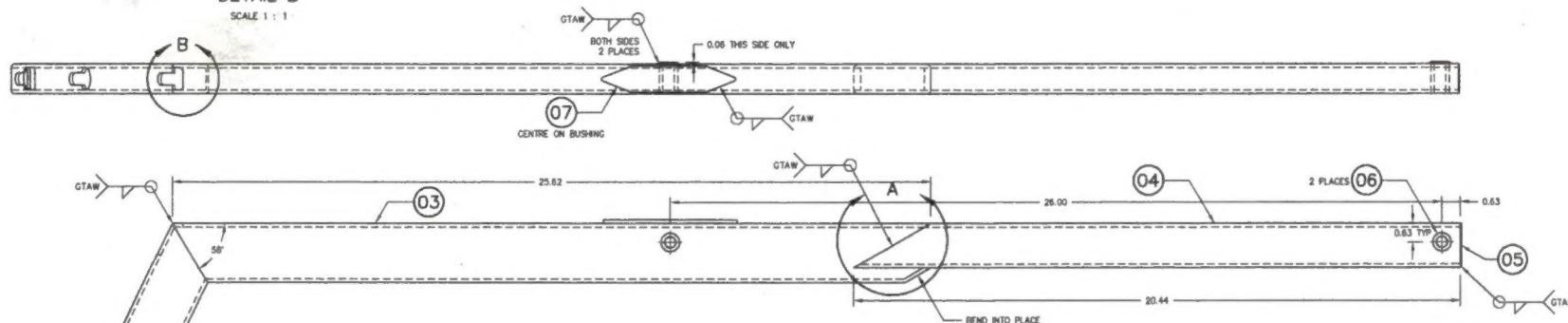
1	M52(044C)	CSU					
	#10-32	NUT		STAINLESS STEEL	COMMERCIAL		15mm x 70mm SPRING
1	69830-23	13	KNOB				GO-A-200/8
1	69830-23	12	SPRING				GO-A-200/8
1	69830-21	11	KNOB	6061-T6 ALUMINUM	GO-A-200/8		GO-75 ROD
1	69830-21	11	SPRING	6061-T6 ALUMINUM	GO-A-200/8		GO-75 ROD
1	69830-11	10	GUIDE	304 STAINLESS STEEL	ASTM A269		GO-75 x 0.065 RND. TYP.
1	69830-20	09	CAP	321 STAINLESS COND.	AMS 5510		0.025 SHEET
1	69830-19	08	CAP	321 STAINLESS COND.	AMS 5510		0.025 SHEET
1	69830-17	07	BECK	304 STAINLESS STEEL	ASTM A479		0.25 X 1 1/2 ROD
1	69830-18	06	STRAP	304 STAINLESS STEEL	MLL-S-3059		0.100 SHEET
2	69830-15	05	BUSHING	304 STAINLESS STEEL	AMS A213		GO-625 X 0.120 TUBE
2	4930-34	04	CAP	321 STAINLESS COND.	AMS 5510		0.025 SHEET
1	49730-03	03	TUBE	304 STAINLESS STEEL	ASTM A554		2 X 1 X 0.12 TUBE
1	49730-02	02	DOWN TUBE	304 STAINLESS STEEL	ASTM A554		2 X 1 X 0.12 TUBE
1	49730-01	01	FORWARD BEAM ASSEMBLY				
D1	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC		STOCK SIZE
QTY				LIST OF MATERIALS			
APPROVALS _____ DATE _____ DRAWN: JEFF CLARKE 01 OCT 2008 CHECKED: E. BURCOIN				AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVED, DAR BROW 8019 - 50TH AVENUE M.E. CAGAN ALBERTA, CANADA T0E 0B7 tel: (403) 850-9007 fax: (403) 850-9335 www.aerodesign.ca			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:				BELL 206B QUICK RELEASE MOUNTING POSITIONS FORWARD BEAM FABRICATION			
DECIMALS .0010 ANGLES ±1/2° XXX ±0.03 X.X ±0.1				SCALE 1 : 2 DWG. SIZE (DWG. NO.) REV. SHEET 1 OF 1 A1 49730 1			

2016-128

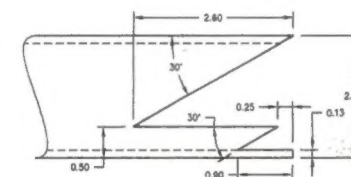
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



DETAIL B
SCALE 1 : 1



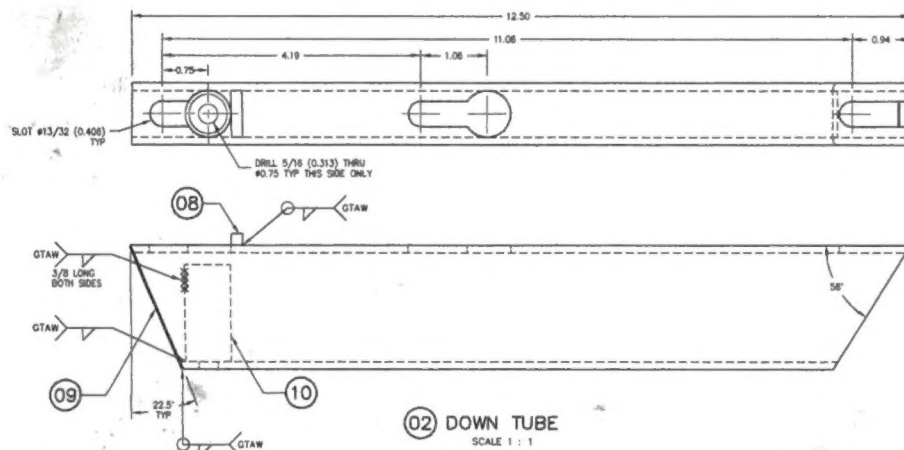
01 AFT BEAM ASSEMBLY



DETAIL A
SCALE 1 : 1

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2885C. WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT FOR STAINLESS STEEL.
3. ALL STEEL PARTS TO BE THOROUGHLY DEGREASED AND POWDER COATED PRIOR TO INSTALLATION.



02 DOWN TUBE
SCALE 1 : 1

1	MS21044C3	NUT	STAINLESS STEEL	COMMERCIAL	15mm x 70mm SPRING	
1	#10-32	C-SUNK SCREW	STAINLESS STEEL	COMMERCIAL	15mm x 70mm SPRING	
1	68830-23	13 SPRING	8061-T6 ALUMINUM	QQ-A-200/28	#0.75 ROD	
1	68830-22	12 KNOB	8061-T6 ALUMINUM	QQ-A-200/28	#0.625 ROD	
1	68830-21	11 STOP	304 STAINLESS STEEL	ASTM A289	#0.75 X 0.065 RND.	
1	68830-11	10 GUIDE	321 STAINLESS COND. A	AMS 5510	0.025 SHEET	
1	68830-19	09 CAP	304 STAINLESS STEEL	ASTM A479	0.188 SQ. ROD	
1	68830-07	08 BLOCK	304 STAINLESS STEEL	MIL-S-3058	0.100 SHEET	
2	68830-16	07 STRAP	304 STAINLESS STEEL	ASTM A213	#0.625 X 0.120 TUBE	
1	49731-05	05 CAP	321 STAINLESS COND. A	AMS 5510	0.025 SHEET	
1	49731-04	04 TUBE	304 STAINLESS STEEL	ASTM A554	1.5 X 1 X 0.12 TUBE	
1	49731-03	03 TUBE	304 STAINLESS STEEL	ASTM A554	2 X 1 X 0.12 TUBE	
1	49731-02	02 DOWN TUBE	304 STAINLESS STEEL	ASTM A554	2 X 1 X 0.12 TUBE	
1	49731-01	01 AFT BEAM ASSEMBLY				
Q1	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
<div>APPROVALS</div> <div>DATE</div> <div>AERO DESIGN LTD.</div> <div>DR: JEFF CLARKE</div> <div>01 OCT 2008</div> <div>CONSULTING ENGINEERS, TRANSPORT CANADA AIRPORTS, DR 5901</div> <div>0101 - 50TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2B 0P7</div> <div>PHONE: (403) 860-8007</div> <div>FAX: (403) 860-8833</div> <div>www.aerodesign.ca</div> <div>UNLESS OTHERWISE SPECIFIED</div> <div>DIMENSIONS ARE IN INCHES.</div> <div>TOLERANCES ON:</div> <div>DECIMALS</div> <div>ANGLES</div> <div>X.XXX ±0.010</div> <div>±1/2°</div> <div>X.XX ±0.03</div> <div>X.X ±0.1</div> <div>BELL 206B</div> <div>QUICK RELEASE MOUNTING PROVISIONS</div> <div>AFT BEAM FABRICATION</div> <div>SCALE 1 : 2</div> <div>DWG SIZE</div> <div>DWG NO</div> <div>REV</div> <div>SHEET 1 OF 1</div> <div>A1</div> <div>49731</div> <div>0</div>						

APPROVALS DRAWN: JEFF CLARKE CHECKED: E. BURGOIN		DATE 01 OCT 2008
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1		
AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 990M 2015 - 59TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6E7 Tel: (403) 950-8007 Fax: (403) 950-8003 www.aerodesign.ca		
BEL 206B QUICK RELEASE MOUNTING PROVISIONS AFT BEAM FABRICATION		
SCALE 1 : 2 SHEET 1 OF 1	DWS SIZE DWS NO. A1 49731	REV. 0

Work Order: 2016-128Material Tracking Sheet
Bell 206B Forward Mounting Beams

1 of 2

Date Opened: 23 SEPT 2016

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		49730-01	Fwd Beam Assembly		
Step 1				<i>Fabrication</i>		
	.1		49730-02	Tube	304 Stainless, 2x1x0.12 tube	<u>15039</u>
	.1		49730-03	Tube	304 Stainless, 2x1x0.12 tube	<u>15039</u>
Step 2				<i>Machining</i>	<i>None</i>	
Step 3				<i>Fabrication</i>		
	.1		49730-04	Cap	321 Stainless, 0.025" Sheet	<u>3021</u>
	.2		69830-15	Bushing	304 Stainless, 0.625x0.120 tube	<u>15024</u>
	.1		69830-16	Strap	304 Stainless, 0.100" Sheet	<u>13083</u>
	.1		69830-07	Block	304 Stainless, 0.25x0.125 Rod	<u>2016-77</u>
	.1		69830-19	Cap	321 Stainless, 0.025" Sheet	<u>3021</u>
	.1		69830-20	Cap	321 Stainless, 0.025" Sheet	<u>3021</u>
	.1		69830-11	Guide	304 Stainless, 0.075x0.065 Rnd. Tube	<u>2016-79</u>
Step 4				<i>Welding</i>		
	. A/R		--	Welding Rod	ER308L	<u>6037</u>
Step 5				<i>Straightening</i>	<i>None</i>	
Step 6				<i>Inspection</i>	<i>None</i>	
Step 7				<i>Powder Coating</i>		
Step 8				<i>Final Assembly</i>		
Step 8.b.	.1		69830-21	Stop	6061-T6 Aluminum, 0.625 Rod	
	.1		69830-22	Knob	6061-T6 Aluminum, 3/4" Rod	
	.1		69830-23	Spring	15mm x 70 mm Spring	
	.1		69830-1032X3	#10-32 x 3 Screw	Stainless Steel, Commercial	
	.1		MS21044C3	Nut		

Work Order: _____

Material Tracking Sheet
Bell 206B Forward Mounting Beams

2 of 2

Date Opened: _____

Step 8.c.	. 1		--	P/N Placard	TZ Tape, 1/2", black on white	<i>Commercial</i>
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Work Order: 296-128Material Tracking Sheet
Bell 206B Aft Mounting Beams

1 of 1

Date Open: 23 SEPT 16

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		49731-01	Aft Beam Assembly		
Step 1				<i>Fabrication</i>		
	. 1		49731-02	Tube	304 Stainless, 2x1x0.12 tube	<u>15039</u>
	. 1		49731-03	Tube	304 Stainless, 2x1x0.12 tube	<u>15039</u>
	. 1		49731-04	Tube	304 Stainless, 1.5x1x0.12 tube	<u>6081</u>
Step 2				<i>Machining</i>	<i>None</i>	
Step 3				<i>Fabrication</i>		
	. 1		49731-05	Cap	321 Stainless, Min 0.025 Sheet	<u>3021</u>
	. 2		69830-15	Bushing	304 Stainless, 0.625x0.120 tube	<u>15024</u>
	. 1		69830-16	Strap	304 Stainless, 0.100" Sheet	<u>13083</u>
	. 1		69830-07	Block	304 Stainless, 0.188 sqr. Rod	<u>2016-77</u>
	. 1		69830-19	Cap	321 Stainless, Min 0.025 Sheet	<u>3021</u>
	. 1		69830-11	Guide	304 Stainless, 0.75 x 0.065 rnd. Tube	<u>2016-79</u>
Step 4				<i>Welding</i>		
	. A/R		--	Welding Rod	ER308L	<u>6037</u>
Step 5				<i>Straightening</i>	<i>None</i>	
Step 6				<i>Inspection</i>	<i>None</i>	
Step 7				<i>Powder Coating</i>		
Step 8				<i>Final Assembly</i>		
Step 8.b.	. 1		69830-21	Stop	6061-T6 Aluminum, 0.625 Rod	
	. 1		69830-22	Knob	6061-T6 Aluminum, 3/4" Rod	
	. 1		69830-23	Spring	15mm x 70 mm Spring	
	. 1		69830-1032X3	#10-32 x 3 Screw	Stainless Steel, Commercial	
	. 1		MS21044C3	Nut		
Step 8.c.	. 1		--	P/N Placard	TZ Tape, 1/2"	<u>Commercial</u>

MOUNTING BEAM FABRICATION – 49730/49731

General

These instructions apply to mounting beams 49730-01 (forward) and 49731-01 (aft) for Bell 206B low mounted cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

49730, Revision 1 – Forward Beam

49731, Revision 0 – Aft Beam

Work Order: 2016-128

Batch Quantity: 1 / 1

Date Open: 23 SEPT 2016

Complete

(initial or SCA #)

AD
73-04
07

AD
73-04
01

1. Beam Fabrication

- Cut 1 x 2 x 0.12 material as indicated on drawings.
 - 49730-01: 49730-03 (long tube), 49730-02 (down tube)
 - 49731-01: 49731-03 (long tube), 49731-02 (down tube)
- Cut 1 x 1.5 x 0.12 material as indicated on drawings.
 - 49731-01: 49731-04 (far side tube)
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

2. Beam Fabrication - 49731-03 Long Tube

The interface cuts are critical to minimize deflection during welding. Use the full scale template to layout cuts. Ensure correct orientation of tubes before cutting.

- Mark straight cut ends as indicated on template, 0.9" and 2.6" from end.
- Set vertical bandsaw guide to cut along bottom wall of tube, 0.13 from bottom edge. Hold tube tight against guide through cut. Cut to 0.9" mark.

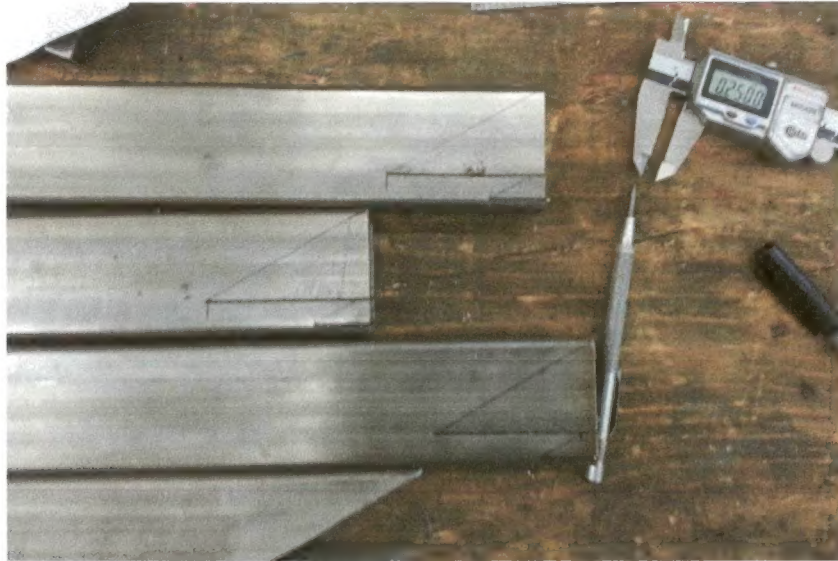


- Set vertical bandsaw guide to cut along 1.5" from top edge. Ensure 49731-04 tube will seat tightly into cutout. Hold tube tight against guide through cut. Cut to 2.6" mark.

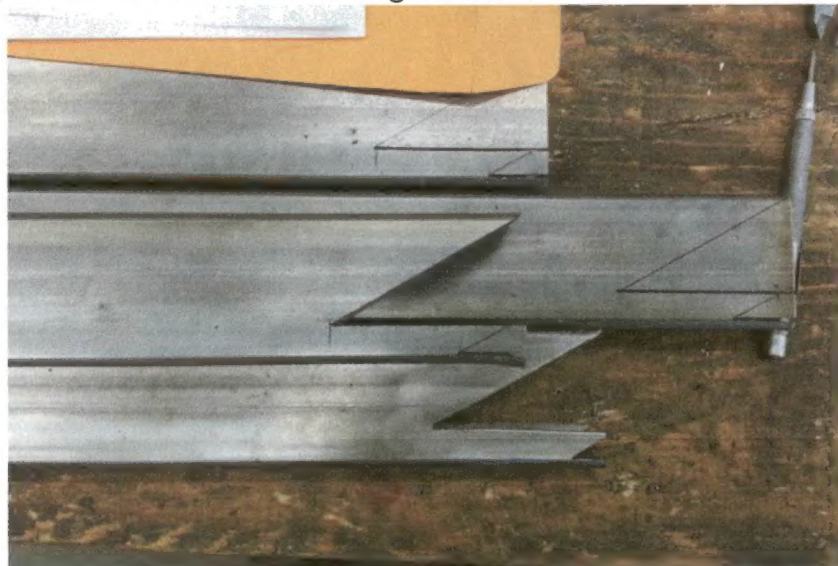


- d. The small tab between the cuts will be sprung out. Squeeze in to ensure tube will sit flat.
- e. Using tube 49731-04 as a guide, layout cut angle to ensure tight fit.

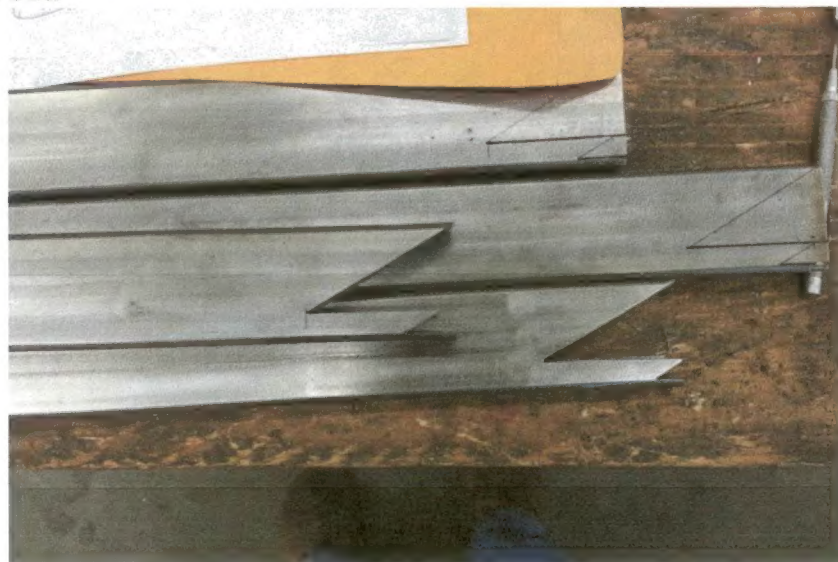




- f. Cut large angle section out. Start cut on edge of end face.



- g. Cut small tab out.



- h. Deburr all cut edges. Tag in-progress parts and place on in-progress shelf in welding shop.

(initial or SCA #)
 FWD AD
 AFT AD
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3. Beam Fabrication – Components

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- a. Shear and bend caps: 69830-19, 69830-20, 49730-04, 49731-05.
- b. Cut and turn 69830-15 bushings and 69830-11 guide tubes:
 - i. Cut stock to length + 0.03-0.06".
 - ii. Face one end flat @ 1000 RPM.
 - iii. De-burr outside with a file and inside with de-burring tool at 300 RPM.
 - iv. Setup stop and face other end to length @ 1000 RPM.
 - v. De-burr outside with a file and inside with a de-burring tool at 300 RPM.
- c. Cut 69830-07 blocks.
- d. Record component POs / WOs on attached material list.

AD AD
 73-04 73-04
 02 02

4. CNC Machining

- a. Run CNC programs to machine keyways, slots and holes in component parts.
 - i. 49720 – Forward beam bushing holes
 - ii. 69805 – Forward and Aft Downtube – Vertical Slots
 - iii. 69804 – Aft beam end slot
- b. De-burr keyways, slots and holes.
- c. Tag in-progress parts and place on in-progress shelf in welding shop for welding.

5. Beam Welding – 49731-03 /49732-04 Tubes

- a. TIG weld 49731-03 Tube and 49731-04 Tube together at scarf joint using ER308L rod.
- b. Record component and welding rod POs / WOs on attached material list.
- c. Tag in-progress parts for straightening.

AD AD
 73-04 73-04
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6. Beam Straightening – 49731-03 /49731-04 Tubes

Note: straightening the beams is critical for ease of installation of the mounting beam and cargo basket.

- a. Straighten beams at scarf joint using hydraulic press.
 - i. Set beam upside down on blocks as far apart as possible, locate ram over scarf joint.
 - ii. Use a block to distribute press loads, min 2" wide
 - iii. Gradually work up to pressure required to make beam straight. The same pressure generally works for beams from the same batch.
 - iv. Check for straight with a straight edge on top of tube. Ensure straight edge does not sit up on weld.

AD AD
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 01 01

7. CNC Machining

- a. Run CNC programs to machine keyways, slots and holes in component parts.
 - i. 49721 – Aft beam bushing holes
- b. De-burr keyways, slots and holes.
- c. Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD AD
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 02 02

FWD AFT
Complete
(initial or SCA #)
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05 05

8. Beam Welding – 49730-01 Forward Beam

- a. TIG weld 69830-11 guide tube into 49730-02 down tube using ER308L rod. Use jig to align guide tube to keyway and hole.
- b. TIG weld 69830-15 bushings into 49730-03 tube using ER308L rod, two places per tube, both sides. Ensure bushings protrude from correct side of beam. Refer to drawings.
- c. TIG weld 49730-03 long tubes (from b) to 49730-02 down tubes (from a) using ER308L rod. Use jig to hold tubes at correct angle.
- d. TIG weld components using ER308L rod:
 - i. 69830-16 strap to beam, centre on bushing, both beams.
 - ii. 69830-07 stop over bottom keyway on forward beam.
 - iii. 69830-19, 69830-20, 49730-04 caps. Ensure top slot on forward beam has sufficient clearance for basket fitting (96710-01 or Ancra 40088-14).
- e. Record component and welding rod POs / WOs on attached material list.
- f. Tag in-progress parts for finishing.

9. Beam Welding – 49731-01 Aft Beam

- a. TIG weld 69830-11 guide tube into 49731-02 down tube using ER308L rod. Use jig to align guide tube to keyway and hole.
- b. TIG weld 69830-15 bushings into 49731-03/-04 tubes (from step 7.) using ER308L rod, two places per tube, both sides. Ensure bushings protrude from correct side of beam. Refer to drawings.
- c. TIG weld 49731-03/-04 long tubes (from b) to 49731-02 down tube using ER308L rod. Use jig to hold tubes at correct angle.
- d. TIG weld components using ER308L rod:
 - i. 69830-16 strap to beam, centre on bushing, both beams.
 - ii. 69830-19, 49731-05 caps.
- e. Record component and welding rod POs / WOs on attached material list.
- f. Tag in-progress parts for finishing.

10. Beam Finishing

Note: straightening the beams is critical for ease of installation of the cargo basket.

- a. Straighten beams at strap using hydraulic press.
 - i. Set beam upside down on blocks as far apart as possible, locate ram over strap/bushing.
 - ii. Use a block to distribute press loads, about 2" wide
 - iii. Gradually work up to pressure required to make beam straight, usually more than 1000 psi is required. The same pressure generally works for beams from the same batch.
 - iv. Check for straight with a straight edge on bottom of tube. Ensure straight edge does not sit up on end cap.
- b. Straighten beams into plane using hydraulic press.
 - i. Check beams for plane by setting beam on a flat surface (welding table) on blocks. Use two blocks under long tube as far apart as possible. Attempt to slide block under end of down tube. Record direction and approximate distance to make block fit.
 - ii. Set beam on block under press ram, as close to corner at down tube as possible. Set the beam so that pushing down on the down tube will straighten the beam.
 - iii. Pressurize ram to 800 psi to hold beam.
 - iv. Clamp a snipe tube to down tube.

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AD AD
73-04 73-04
07 07

- v. Push down on snipe tube. Note pressure on press for applied deflection. Similar deflections will require similar pressure.
- vi. Check beams for plane, repeat steps ii-v if required.
- c. Break sharp edges off strap and stops using sanding disc on die-grinder.
- d. Tag in-progress parts for inspection.

FWD AFT

AD
73-04
01AD
73-04
01

11. Final Inspection

To be completed by a different person than the previous steps.

- a. Inspect beams 49730-01 and 49731-01 for conformity to drawing.
- b. Tag in-progress parts ready for powder coating.

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73-04
02AD
73-04
02

12. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag in-progress parts ready for final assembly.

AD
73-04
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13. Final Assembly

To be completed after powder coating.

- a. Clear powder coat from stop pin hole with 5/16 (#4) centre drill.
- b. Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into bottom guide with 69830-22 knob and MS21044C3 nut. Check for function.
- c. Adhere P/N placard to top surface of beam, between strap and end on top surface.
- d. Green tag completed beam assemblies and place into stock.